

VT-06215

Contract #BRF 0241 (29)

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W53

PROCEDURE SPECIFICATIONS

MATERIAL SPECIFICATION _____ ASTM A709 Gr. 36, 50, 50W
 WELDING PROCESS _____ SUBMERGED ARC WELDING
 MANUAL OR MACHINE _____ SEMIAUTOMATIC OR MACHINE
 POSITION OF WELDING _____ 2F
 FILLER METAL SPECIFICATION _____ AWS A5.17
 WELD METAL CLASSIFICATION _____ F7A2-EM12K
 WIRE/FLUX _____ LINCOLN L61/960
 WIRE DIAMETER _____ SEE BELOW
 SINGLE OR MULTIPLE ARC _____ SINGLE ARC
 POLARITY _____ SEE BELOW
 ROOT TREATMENT _____ REMOVE LOOSE RUST, SCALE AND CONTAMINANTS
 PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART
 ELECTRICAL STICK-OUT _____ 1 INCH
 SHIELDING GAS _____ D.N.A.

VTRANS
 RECEIVED
 OK'D BY _____ OK'D BY Juc
 DEC 19 2006
 RESUBMIT _____ APPROVED
 BY _____ DATE 12-21-06

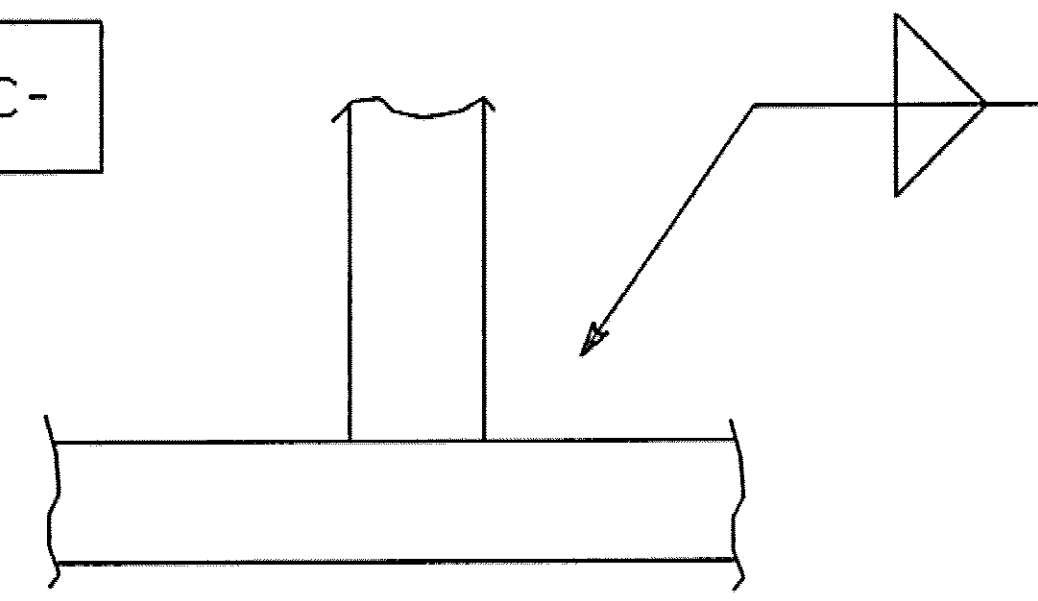
REVISED: 3/24/06
 ORIGINAL ISSUE: 01/01/92

WELDING PROCEDURE

PASS NO.	WELDING CURRENT			TRAVEL SPEED (IPM)	WIRE DIA.	POL.	JOINT DETAIL
	AMPS	WIRE FEED SPEED	VOLTS				
1	400-550	123-217	32.5-39.5	14.0-23.0	5/64 "	DC+	5/16" FILLET WELDS

1	400-550	129-195	32.5-39.5	14.0-23.0	3/32 "	DC-
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PRIMARY USE:
 CROSS FRAMES AND DIAPHRAGMS
 (AND OTHER APPLICATIONS AS NEEDED)



- PROCEDURE QUALIFICATION RECORD AWS-03-5 (EXPIRES 1/28/08)
- PROCEDURE QUALIFICATION RECORD AWS-03-6 (EXPIRES 1/31/08)
- PROCEDURE QUALIFICATION RECORD AWS-03-7 (EXPIRES 2/4/08)
- PROCEDURE QUALIFICATION RECORD 06-01B (EXPIRES 3/24/11)